

Work Order ID 63353

Wednesday, October 27, 2010 4:04:00 PM



Page 1

Item ID: D3255-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Access Panel Assembly

Start Date: 10/27/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 11/11/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

10-10-28

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3255	Rev B

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Weld as per Dwg D3255 ***purge weld***☐A/R SS ROD
Batch: *1114649* ☐2-Grind Welds Flush

24 10/11/09

110

0.00



QC10- Inspect visual per QSI004- ground welds

QC

Memo

0.00

Quality Control

8/10/10/09

120

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

8/10/10/09

74
-0421

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




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Item Name:	Access Panel Assembly				Stop	
Start Date:	10/27/2010	Start Qty:	4.00			
Required Date:	11/11/2010	Req'd Qty:	4.00			
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 <i>M 112588</i> Memo START TIME: <i>3:45</i> <input type="checkbox"/> OVEN TEMPERATURE: <i>320°</i> <input type="checkbox"/> FINISH TIME: <i>4:15</i>	0.00 0.00				<i>4</i>	<i>12</i>	<i>10-16-11</i>	
140  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		<i>10/11/12</i>		<i>4</i>	<i>0</i>		
150  Small Fab Small Fab	Small Fab Memo 1-Bond D3255-5 gasaket to d3255-042 using Dow corning adhesive as per Dwg D3255□A/R 736 DOW CORNING ADHESIVE Batch: <i>M 111718</i>	0.00 0.00						<i>10/11/16</i> <i>(E)</i>	

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Item ID: D3255-042

Accept

Setup Start

Revision ID:

Stop

Item Name: Access Panel Assembly

Start Date: 10/27/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 11/11/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

801117

24
242

170



Packaging

Packaging

Identify as per dwg & Stock Location: 176

0.00

Memo

0.00

C 10/11/16 (4)

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

OK 10/11/17

10-11-17
(4)

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Picklist Print

Wednesday, October 27, 2010 4:04:04 PM

Page 1

Work Order ID: 63353



Parent Item: D3255-042



Parent Item Name: Access Panel Assembly

Start Date: 10/27/2010

Required Date: 11/11/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:C Removed Manufacturing of D3255-1/-2/-3 06-08-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3255-2 Panel		Manufactured	No			100	Each	5.0000	1	4		10/11/08	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				5					
					61686			5					
D3255-5 Gasket		Manufactured	No			100	Each	5.0000	1	4		10/11/16	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST047				5					
					60207			84					
D3255-3 Cap		Manufactured	No			150	Each	6.0000	1	4		10/11/08	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				6					
					48315			6					

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

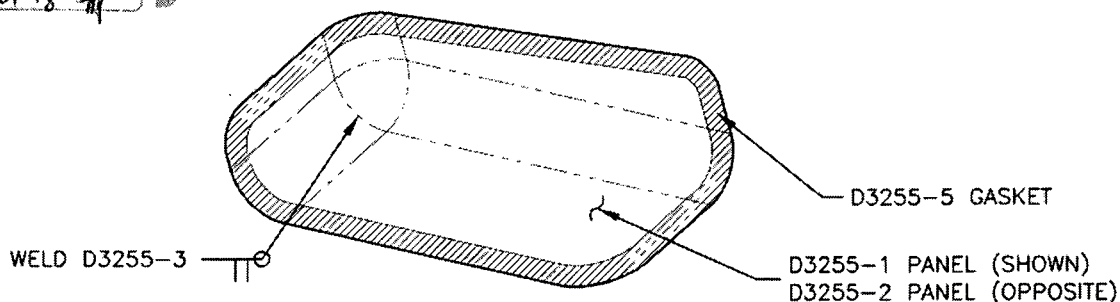
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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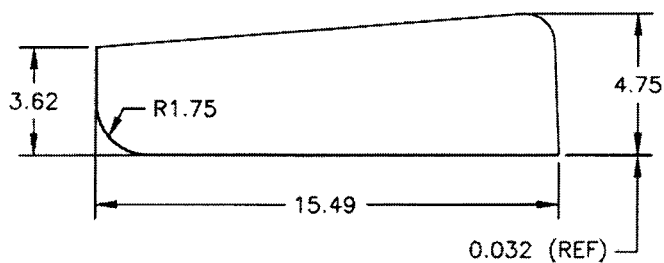
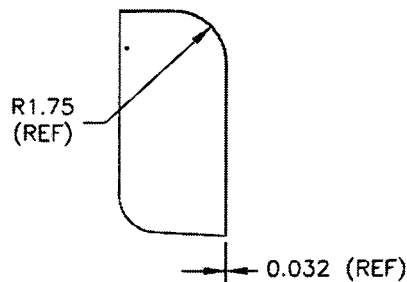
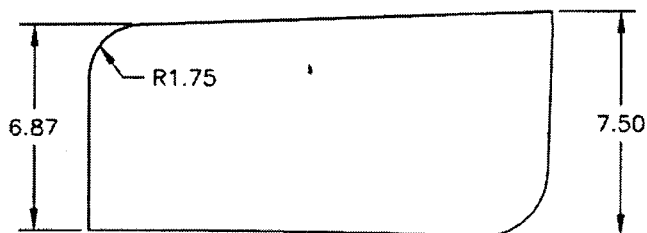


DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED if	APPROVED #	DRAWING NO. D3255	REV. B SHEET 1 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:6
A	04.01.27	NEW ISSUE	
B	04.12.06	D3255-3 REDESIGN; ADDED Ø0.098	

RELEASED
05-01-18 #



D3255-041 ACCESS PANEL (SHOWN)
D3255-042 ACCESS PANEL (OPPOSITE)



D3255-1 BEND DETAIL
D3255-2 OPPOSITE

D3255-041/-042 NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **43353**

2810-10-28

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Dart Aerospace Ltd

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

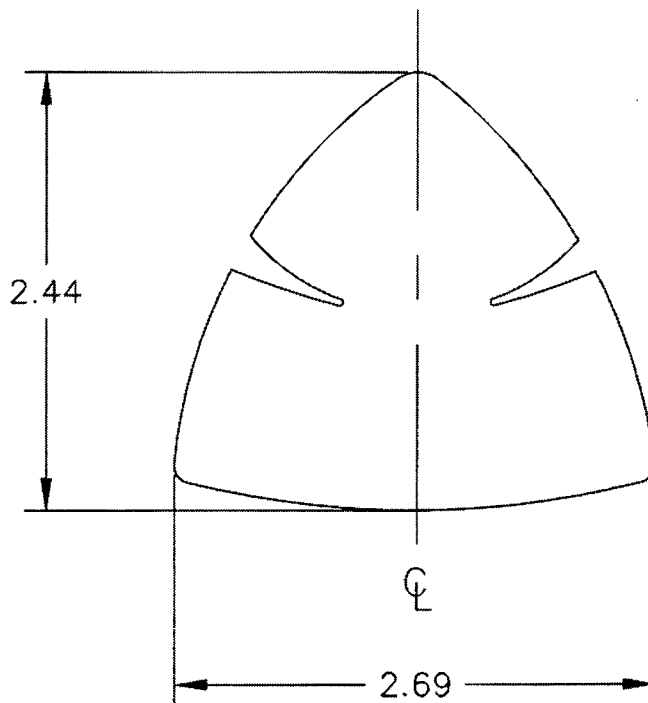
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries



DESIGN TF	DRAWN BY TF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED up	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 2 OF 4
DATE 04.12.06		TITLE TITLE	SCALE 1:1

RELEASED
05.01.08 [Signature]



D3255-3 CAP
FORM TO FIT D3155-1/-2

w/c 63353

D3255-3 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

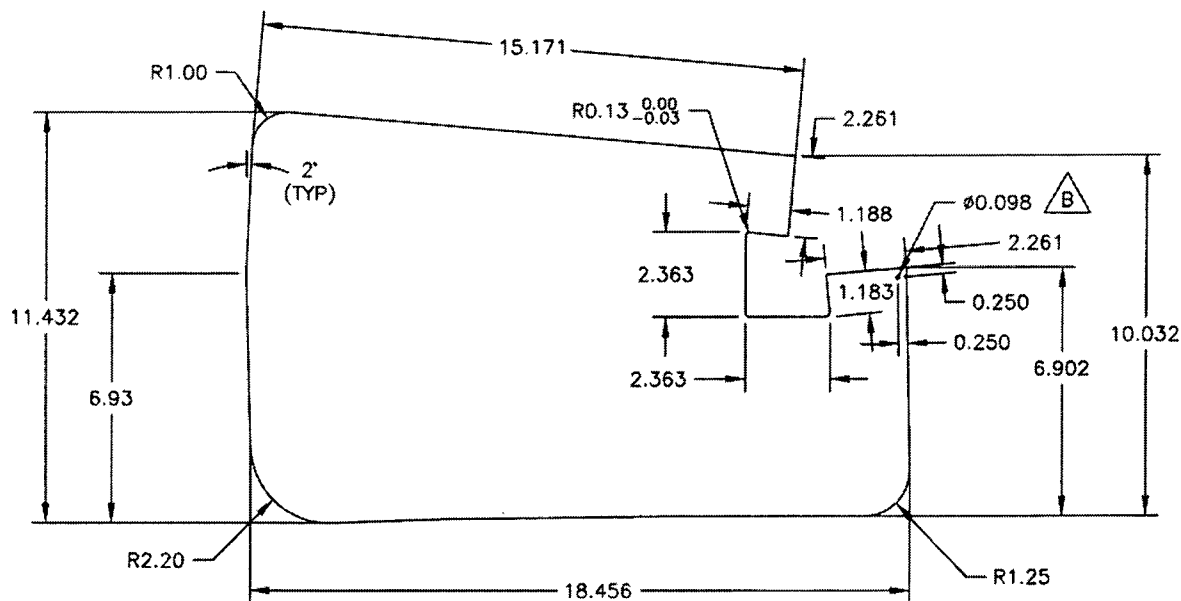
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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CHECKED UP	APPROVED HT	DRAWING NO. D3255	REV. B SHEET 3 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED
05-01-18



W/O 43353

D3255-1/-2 FLAT PATTERN

D3255-1/-2 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Dart Aerospace Ltd

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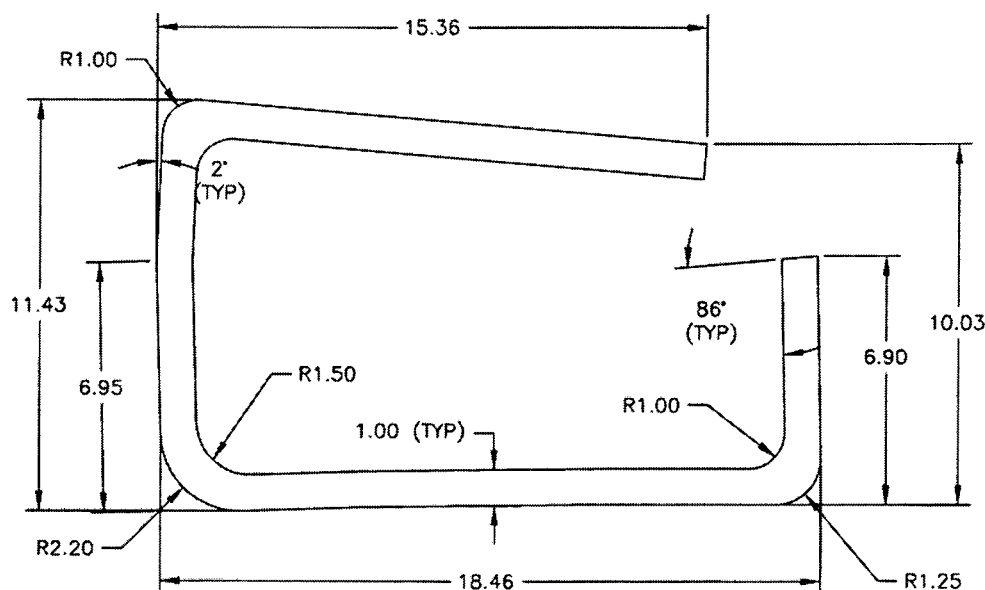
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NOTE: Date & initial all entries



DESIGN JF	DRAWN BY JF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED JF	DRAWING NO. D3255	REV. 8 SHEET 4 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED
05 01 18 JF



D3255-5 GASKET

w/o 43353

D3255-5 NOTES:

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F
P/N SIL/F 36x36x1/16
POSSIBLE SUPPLIER: AVIAL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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